DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028170
Date Inspected: 11-Aug-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	See Below		**CWI Present:**	☑ Yes	☐ No
Inspected CWI report:	☐ Yes	☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No ☐ N/A
Electrode to specification:	☑ Yes	☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No ☐ N/A
Qualified Welders:	☑ Yes	☐ No ☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No ☐ N/A
Approved Drawings:	☑ Yes	☐ No ☐ N/A	**Approved WPS:**	☑ Yes	☐ No ☐ N/A
			Delayed / Cancelled:	☐ Yes	☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG and Tower

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Rodney Patterson-OBG E13 (Observation of excavations, repair welding and production welding, QC inspection and testing of floor beams) and one (1) issue noted, see Summary of Conversations.

Fritz Belford-OBG W12 Drop-In Assembly (Observation of repair welding, QC inspection and testing) and observed QC/UT of 12W-13W-A1.2.

Doug Frey-E12 Corner Drop-In Ass'y(Observation of welding, QC inspection and testing of deck plate field splices) and observed QC/UT of weld no. 12E-PP111.1-C1.

Joselito Lizardo-OBG W13, Drop-In Panels (Observation of excavations, repair welding, production welding, QC inspection deck stiffener flanges, deck plate field splices and removal of lifting rod ass'y).

Matt Daggett-OBG E12(Observation of welding, QC inspection and testing of deck access holes) and OBG W12 (Observation of excavation, repair welding, QC inspection and testing).

William Clifford-Tower Shear Plates/ESW "B" (Observation of excavation, repair welding, QC inspection and testing) and QA/MPT verification of excavations.

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Rodney Patterson, Fritz Belford and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also reviewed RWR documents for tracking purposes.

Summary of Conversations:
There were general conversations with Quality Control Lead Inspector, William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Issue

This QALI also was notified by the QA inspector, Rodney Patterson, that at the weld identified as 13E-PP122.2 there were two (2) UT rejects located at Y coordinates 4580 mm and 4830 mm that required a submittal of an RWR by the contractor. These items are classified as a second time repair, R2, in which the contractor elected to perform the excavation and weld repair prior to the engineer's approval. At the conclusion of this notification, this QALI directed Mr. Patterson to generate and submit an Incident Report (IR) to the QA Task Leader, William Levell, for his review and disposition.

Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer